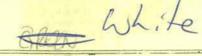
SPLIT-2



Dart Aerospace Ltd

: SADDLE FITTING, AFT (OUTROARDING ARD)

Qty:

Thursday, 6/21/2007 2:28:39 F Kim Johnston

Process Sheet

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-	10	MAL	16	
- 11	me have	Ritar	W 100 1	-

: CU-DAR001 Dart Helicopters Services

Estimate Number

10533 AIH

P.O Number This Issue Prsht Rev.

6/21/2007

NA

S.O. No. : NA

First Issue Previous Run 32167

Written By

Checked & Approved By

Comment

As Per RevE 06-01-27

: MACHINED PARTS

JLM

Drawing Revision Material Due Date

Drawing Name

Part Number

D2573 REV E

Drawing Number : N/A Project Number

NIA 7/11/2007

Additional Product



Machine Or Operation

Est

Description:



1.0000 Each(s)/Unit Total 12,0000 Each(s)

7075-17351 8.25X7.75X2.5

Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length

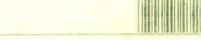
Batch No: 1225355

Comment: Qty.:

HAAS ONC VERTICAL MACHINING #1







Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. Standard Double check by: T-F-

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4 Deburr and remove all machining marks

5-Tumble to remove sharp edges.

CONVENTIONAL MILLING MACHINI







Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2573 & D2574

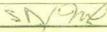


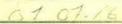
INSPECT PARTS AS THEY COME OFF MACHINE

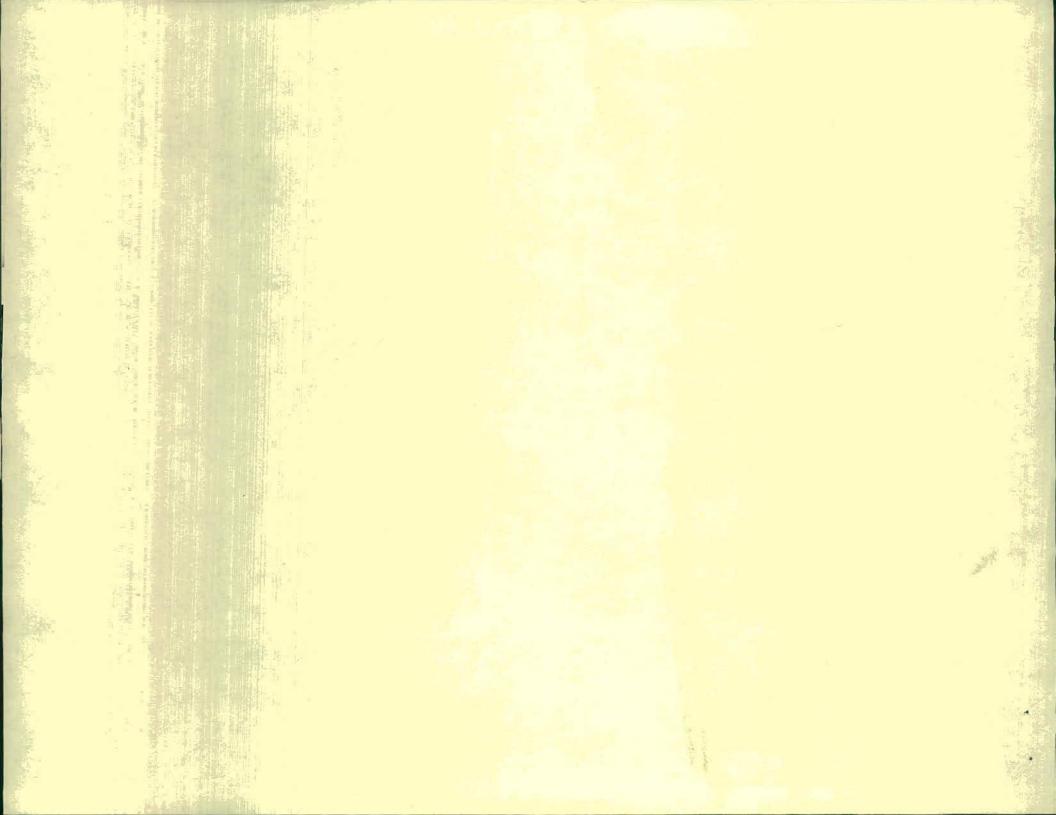




Comment: INSPECT PARTS AS THEY COME OFF MACHINE







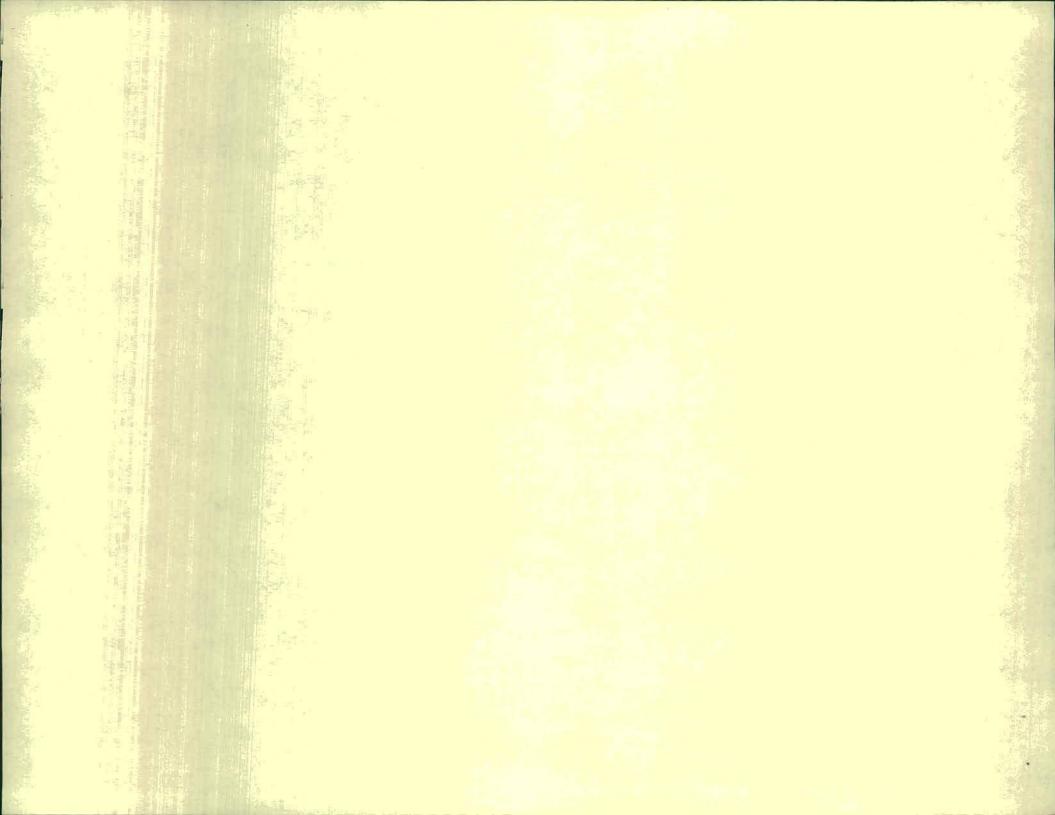
Thursday, 6/21/2007 2:28:39 PM Date: Kim Johnston User. **Process Sheet** Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARL) Customer: CU-DAR001 Dart Helicopters Services Part Number: D2573 Job Number: 33042 Job Number Description: Seq. # Machine Or Operation SECOND CHECK Comment SECOND CHECK HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodina as per QSI 605 4.1 POWDER COATING Comment: POWDER COATING 4.3.5.1) as per QSI 005 4. Comment: INSPECT POWDER COAT PACKAGING RESOURC Comment: PACKAGING RESOURCE #1 Identify and Stock

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.07.18



DART AEROSPACE LTD	Work Order:	34, 1-2
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
A	0.438	0.443	DI2662	15/58	0 941	F 439	2 438		
B .	1.745	1.755		1.757	1 750	7. PSD	3 526		
0	3.495	3.505		3 05	3.500	3 50 6	3 400		
D	1.745	1.755		1.70	1. 7.5%	1 -57-	F- 75 K		
E	7.990	8.010		000/	8.000	J. 1848	7.590		
F	0.490	0.510		776	8 50H	0. 25	1 509		
G	0.257	0.262	DT8683	357	0 258	C 258	2 353		
FI	0 375	0.380	DI8684	. 376	B 377	C 77	8 327		
t	0.490	0.510		. 300	4503	0.073	1500		
	1.174	1.184		1 175	1 178	1 75	0 128		
K	0.558	0.578		1595	0571	(X = 2)	8 5 7		
1	1.174	1.184			1178	1728	7 1 1-5		
M	1.365	1.375		1370	1 7 8	1 = 63	1 368		
74	2.495	2.505		2478	2.500	3.577	2 449		
0	4.119	4.129		9 12 4	4-121	121	4/22		
P	0.115	0.135		-124	0 33	6 123	(133		
Q	0.115	0.135		134	0.135	0.35	1 135		
R	0.240	0.260		-230	0 149	0 19	4 348		1190
- <u>S</u>	0.115	0.135		4123	2.1.2.8	2 120	C 18 8 C 18 8 C 18 8		
	0.178	0.198		1 88	0.88	0.188	C1188		
U	3.210	3.250		323/	3 230	3 130	S 236		
V	0.230	0.250		.242	0.242	6-41	2 24 3		
W	0.115	0.135		- 127	0-121	6 23	6126		
X	0.308	0.313		0.4	0 261	2 3/2	C 375		
Y	0.760	0.765		765	0 261	0 761	1 761		
Z	0.352	0.372		-364	0358	0-161	(15/D		
AA	0.470	0.530		1,00	0.500	1 The	0.500		
AB	0.615	0.635		-0635	0620	4 1.34	0.625		
AC	0.053	0.073		-063	0.663	0103	1763		
AD	0.240	0.260		- 1278	9 246	5445	6 24 F		
AE	1.500	1.520		151/		1012	1509		
AF	0.115	0.135		11.25	0 255	0 30	0.138		
AG	0.240	0.280		.252	0 255	0 21.6	6.265		
AH	0.240	0.260		.252	0.320	1 253	2 351		
Al	2.000	2.020		2,002	3,001	2003	2.00A		
AJ	0.023	0.043		333	0.033	6 1 3 7	4 63 5		
	Acc	ept/Reje	ct						

Measured by: \S\S\S\S\S	Audited by
Date: 07/00/13	Date: 07/07/5

Date	Change	Revised by	Approved
	New Issue	RF	
02.09.26	Re-format; Added Rev. D	KJ	
02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
05.05.05	Added dimension Al	KJ/RF	1
05.12.05	Added dimension AJ	KJ/JLM X	Chil
	02.09.26 02.10.11 05.05.05	New Issue 02.09.26 Re-format, Added Rev. D 02.10.11 Re-format, Added DT8682, DT8683, DT8684 05.05.05 Added dimension Al	New Issue RF 02.09.26 Re-format, Added Rev. D KJ 02.10.11 Re-format, Added DT8682, DT8683, DT8684 KJ 05.05.05 Added dimension Al KJ/RF



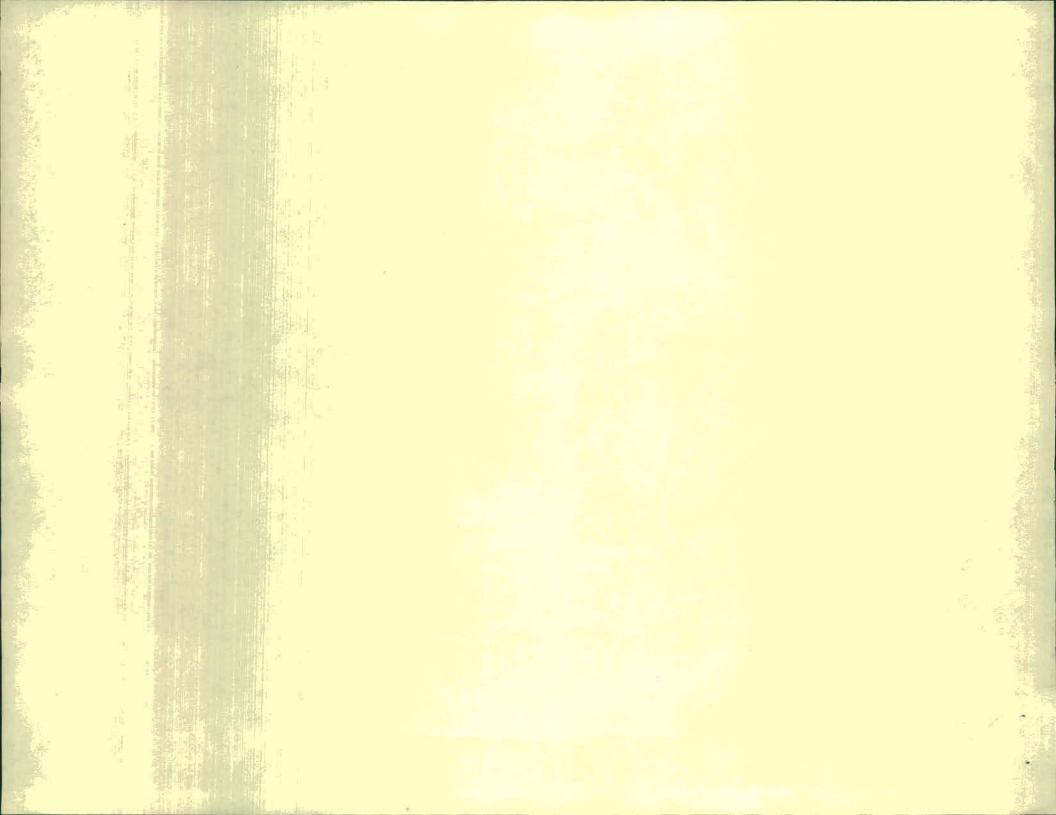
DART AEROSPACE LTD	Work Order:	32
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg; D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
A	0.438	0.443	DT8682	9/300	777	11 - 1 8	335		
В	1.745	1.755		1210	1 300	12.0			
C	3.495	3.505		3	3. 45	7 3 32	3 400		
D	1.745	1.755		1267	7-0	1.71			
E	7.990	8.010		2.33.2	8 12	7.003	S T X		
E	0.490	0.510		774	7 7	. Y 1 S	· rec		
G	0.257	0.262	-DT8683	1255	5 255	2332	15		
14	0.375	0.380	DT8684	8 13 2	0 177	377	3 7 8		
1	0.490	0.510		(572	0302	7	4 4 0		
J.	1.174	1.184		1.178	1178		7.7		
K	0.553	0.578		15/19	6 326				
L	1.174	1.184		1 178	17-8	1 3 8	1 4 th		
M	1.365	1.375		1 3 (3)	1369	1.70	17 20		
N	2.495	2.505		3-566	2.564	100	2 - 31		
0.	4.119	4.129		4121	4. 8 4 7	13	4 120		
P	0.115	0.135		E 123	0.123	24			
Q	0.115	0.135		0 35	0.125				
R	0.240	0.260		10 x 119	0.249	2 3 7	1552		
Ş	0.115	0.135_		8 120	E 13.1	1 1 1 1	2.7		
T T	0.178	0.198		0.88	C: 155	0-38	6 158		
U	3.210	3.250		3.236	3. 230	3.2.2	3,232		
V	0.230	0.250		0240	0.246	205	273		
W	0.115	0.135		1173	6123		123		
X	0.308	0.313		5307	5/17	117	340		
Y	0.760	0.765		.762	762	- 4-2	76-		
Z	0.352	0.372		364	- 355	Sury	-36-1		
AA	0.470	0.530		t. 506_	0.500	8 500	1.500		
AB	0.615	0.635		625	-621	22.5	620		
AC	0.053	0.073		€ 063	0.063	0013	1.06		
AD	0.240	0.260		0246	0248	152			
AE	1.500	1.520		1511	1511		572		
AF	0.115	0.135		0-135	0-13-2	100			
AG	0.240	0.280		0.255	0.257	- 205	265		
AH	0.240	0.260		6 250	0.150	-133	2.7		
Al	2.000	2.020		2.001	2.002	2.302	255		
AJ	0.023	0.043		033	0.53	-E 3/3	033		
	Ace	cept/Reje	ct						

Measured by:	- Ant	Audited by	× 7/17	3
Date:	07/17/13	Date:		

Rev	Date	Change	Revised by	Approved
А		New Issue	RF	
В	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	-1
E	05.12.05	Added dimension AJ	KJ/JLM X	Chal

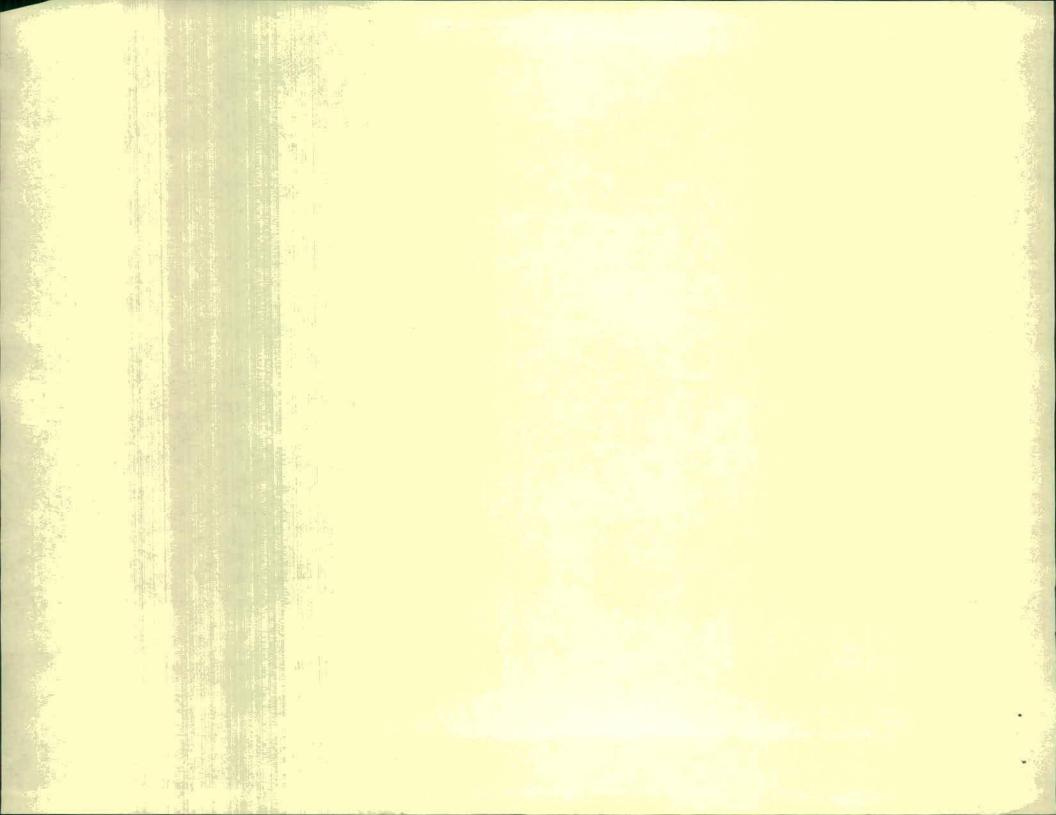


CART AEROSPACE LTD	Work Order:	33042
The second secon	Part Number:	D2513
DIS TI SACOLE, MIL COLOMBIA		2011

ons Aigi	lylifes i miñ spe	Rec	orded Actua	l Cimensio	ns	
Mar	Galles G	1	2			
"F(_\$A_)	-	439	438			
7 3.80 754		3,000	1750 1750 8 005			
100		8.002	8.005			
1 M7	7	.258	-500			-
1.50	PITTOR	376	1507			
		1-750 1-750 1-750 1-750 1-755 1-	1.178			
110		1-370	1370			
		2.498	2.456			
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		250	3.232			
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		-3/9	-310			
0.76		-363	-365			
0.6.0		1	-310 -763 -363 -500 -638			
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		1.510	1.511			
0.260		. 20/	2002			
0.250 2.020 0.043		2.002	7.007			
ceotiRe	iect			Table 1	7 =	07)
5	A.01 16		1	Condition of the Land	27.	21/

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61	While of a	3 4 2 4
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nte.	Change	RE
	New Issus	181
9 26	Re-format, Added Rev. D	W. I
0.14	Re-format, Added DT8682, DT8683, DT8684	VIOL
15 05 05	Added dimension Al	KJURM Z
5 (2.05	Auded dimension AJ	1.2



DART AEROSPACE LTD	Work Order:	33042
Description: Saddle, Aft Outboard	Part Number;	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
AX	0.438	0.443	DT8682	36 Y-	.43=	4759	755		
8	1.745	1.755		67x0	6 7-50	6. 730	1750		
C	3.495	3.505		3 200	7000	7 500	3 20		
D	1.745	1.755		7-50	7-3	8 7-6C	17.0		
	7.990	8.010		1000	3.000	7 2 -	O Car		
	0.490	0.510		756	Y TY	TOP	- 5 17		
	0.257	0.262	DI8683	ST C.	2.18	21			
	0.375	0.380	DI8684	376	376	- 1	3/6		
	0.490	0.510		- 501	-325	307	561		
	1.174	1.184		1 / 27	1-7-23	648	The Til		
	0.558	0.578		270	. 51	· Siet I	SEC		
1	1.174	1.184		117	1. 24	1 , 7 5	74		
P.A	1.365	1.375		1770	1,20	1 11	1300		
TU	2 495	2.505		2501	2.411	2 77 .	318		
	4.119	4.129		5:123	N. 124	the said	-124		
T/S	0.115	0.135		-12 3	=129	2 3	122		
13	0.115	0.135		135	. 35		-234		
展	0.240	0.260		- 247	-,2 50	277	230		
(4)	0.115	U.135	1111	122	112	115			
	0.178	0.198		-170	288	- 1/8	1 0x		
	3.210	3.250		3 232	3232	T. 2 92	3.232		
	0.230	0.250		,244	2 7 2	275	242		
	0.115	0.135		124	.122	124	124		
A.	0.308	0.313		311	320	5//-	- 3-6		
	0.760	0.765		762	-163	56 7	703		
	0.352	0.372		,365	364	362	363		
AA	0.470	0.530		- 200	-500	500	- 87X		
AB	0.615	0.635		624	-632	627	6.26		
AC	0.053	0.073		-C63	2300	065	0/3		
AD	0.240	0.260		276	-247	17-84	-27)		
A.E	1.500	1.520		5/1	1-511	1 3 11	180		
AR	0.115	0.135		135	35	737	153		
AG.	0.240	0.280		255	1260	200	=100		
	0.240	0.260		150	-252	5.3	232		
Al	2.000	2.020		2-002	2002	2.003	2001		
	0.023	0.043		033	C33	633	Ois		
	Acc	ept/Reje	ct						

Measured by:	3/3	Audited by	7-1	
Date:	0101-7	Date:	0.7	107110

Rein	Date	Change	Revised by	Approved
A		New Issue	RF	
8	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	1
E	05.12.05	Added dimension AJ	KJ/JLM X	all
				7

